

# Work Order ID 92648

November-06-12 12:28:58 PM

**\*92648\***

Page 1

Item ID: D4034-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Aft Upper Rib Assembly

Start Date: 11/14/12 Start Qty: 1.00

Required Date: 11/23/12 Req'd Qty: 1.00

\*1\* (3x)  
\*1\*

Cust Item ID:

Customer:

Reference:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Approvals:

Process Plan: MLS

Date: 12-11-07 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4034

B

100

Weld per dwg A/R S.S. rod Batch: 1122130 0.00

**\*100\***

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

CC 12-11-20

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Memo

0.00

Quality Control

(3) 12-11-21

DAS  
09  
8-83

120

QC5- Inspect part completeness to step on W/O 0.00

**\*120\***

QC

Memo

0.00

Quality Control

(3) 12-11-21

DAS  
09  
8-83

# Work Order ID 92648

\*92648\*

Page 2

November-06-12 12:28:58 PM

Item ID: D4034-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Upper Rib Assembly

Start Date: 11/14/12 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 11/23/12 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: *W/A*

0.00

\*130\*

Packaging

Memo

0.00

Packaging

*(3x) CC 12-11-21*

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

*12/11/22*  
*ME*  
*12-11-21*

# Picklist Print

November-06-12 12:28:58 PM

Page 1

Work Order ID: 92648

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly



Start Date: 11/14/12

Required Date: 11/23/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC  
verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC  
IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D4034-1 Rib		Manufactured	No			100	Each	11.0000	1	1		CC 12-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		11		B 89319			(3x)		
				83755		1							
				86176		10							
D4034-3 Rib		Manufactured	No			100	Each	10.0000	1	1		CC 12-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10		B 89359			(3x)		
				58408		0							
				84590		1							
				89319		9							
 D4021-7 Hoop		Manufactured	No			100	Each	41.0000	1	1		CC 12-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		41							
				56996		0							
				87487		1							
				88428		27					(3x)		
				89265		13							

# Picklist Print

Page 2

November-06-12 12:28:58 PM

Work Order ID: 92648

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 11/14/12

Required Date: 11/23/12

Start Qty: 1.00

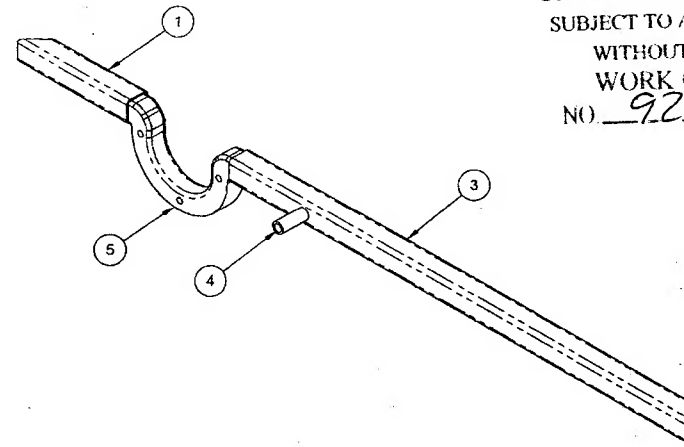
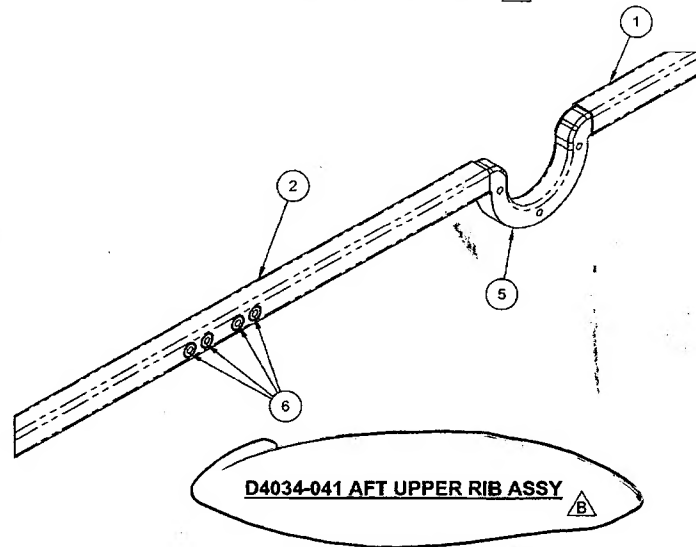
Required Qty: 1.00

✓ D4021-9 Manufactured No  
Bushing

100 Each 130.0000 4 4 CC 12-11-20

Location	Loc Qty	Loc Code
WA	120	
66437	0	
72482	0	
82977	1	
84717	3	
88077	23	
88377	7	
92020	86	12x
WA005	10	
66437	2	
70333	4	
72482	4	

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING

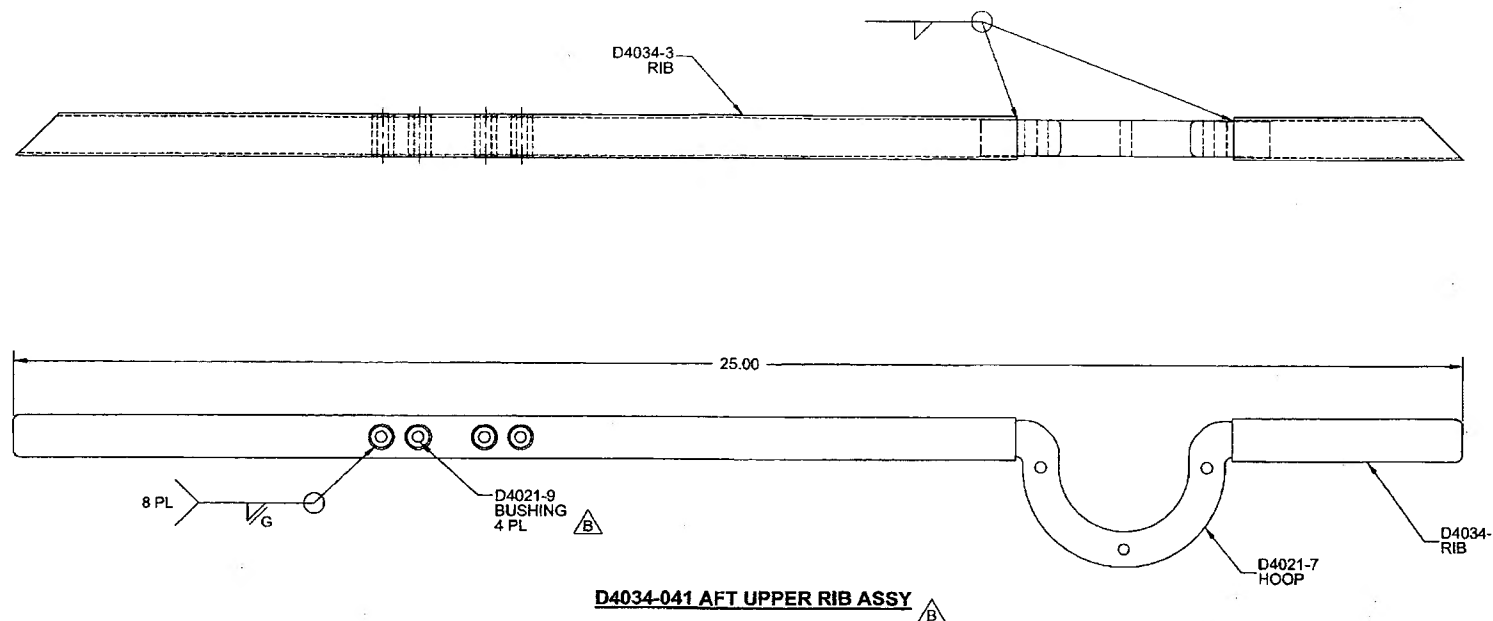


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 92648 MLJ  
12-11-07

RELEASED  
2011-01-18  
JM

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	R	DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR VENDED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

92648



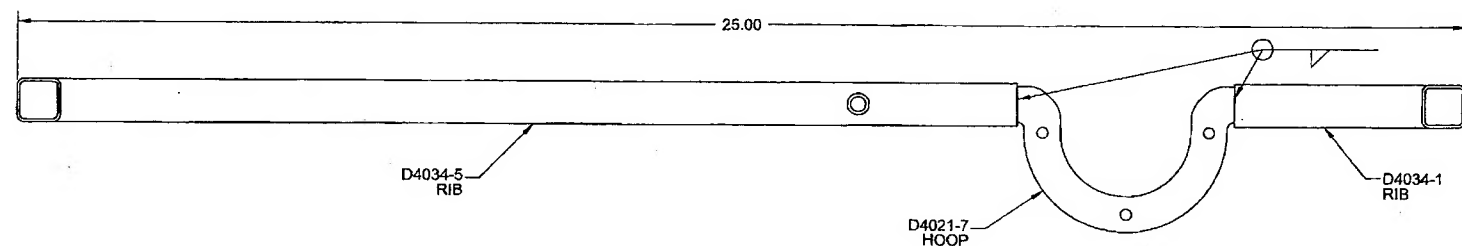
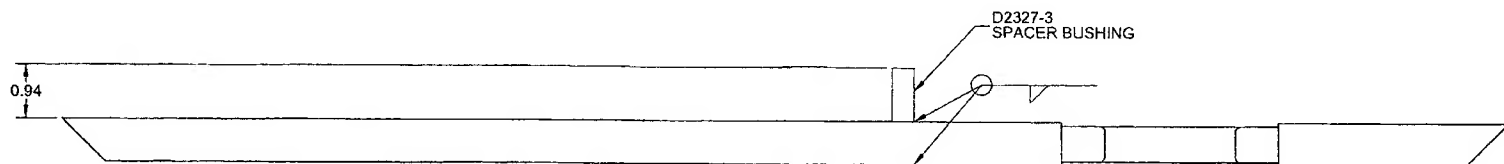
**D4034-041 AFT UPPER RIB ASSY** B

**RELEASED**  
2011-01-30

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.61 lbs
  - 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4034</b>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>UPPER RIB ASSY, BASKET BASE</b>	NTS
DATE	10.12.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

92648





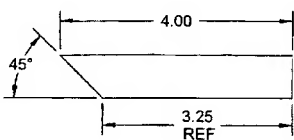
**D4034-043 FWD UPPER RIB ASSY**

**RELEASED**  
R 2011-01-18

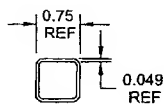
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

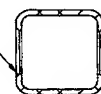
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.		<b>D4034</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>UPPER RIB ASSY, BASKET BASE</b>	
DATE	10.12.20	MTS	
<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>			



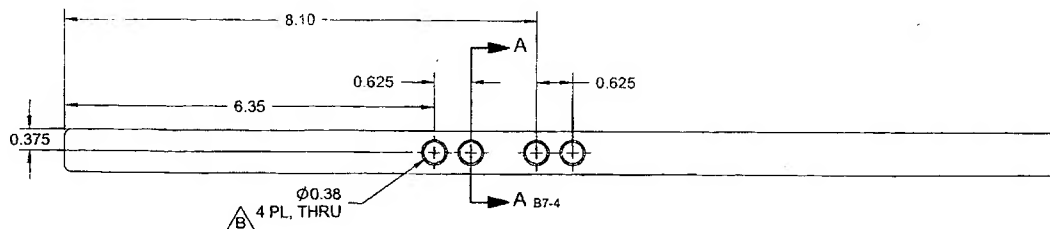
**D4034-1 RIB**



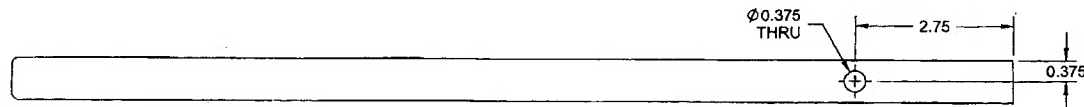
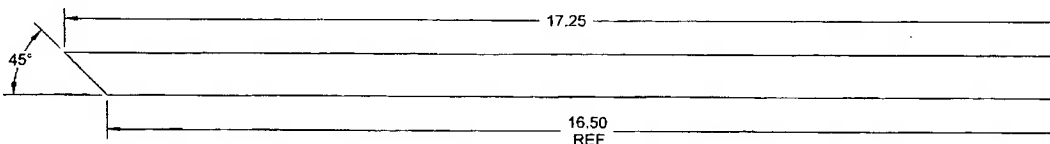
BREAK EDGE  
0.030 X 45°  
TYP



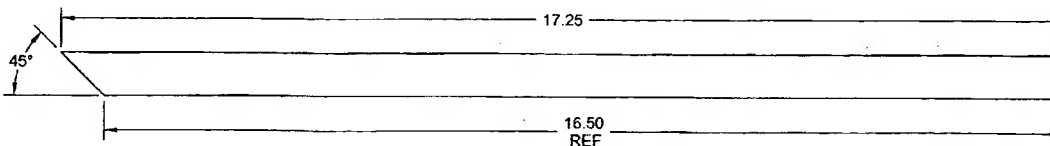
**SECTION A-A D4-4**



**D4034-3 RIB**



**D4034-5 RIB**



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs  
-3 & -5: 0.62 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4034</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>UPPER RIB ASSY, BASKET BASE</b>	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PURPOSE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
2011-01-10

92628